Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.	CNC/QA/FM/02
Rev. No.	01
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12571	24/66
2	Machined By		V.T.L M/c Shop	Drg No- LSP 320 (A)
3	Pallet Die No.		12893 (6.0mm)	CRev 06
4	Die Category	Drg. No.	M. Jumbo 3200 VL-413mm	
5	Out Side Diameter	Drg. No.	680.1mm Step- 673mm	Step Length-31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper- 8°
7	Width of Pellet Die	Drg. No.	195mm	
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X8mm	4X8
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 2 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-34mm Tapping Depth-31.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
	Inspected By (Sign) & Date		Ramanpreet Singh 16/08/24	
1	As per programme no.		—	
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter-30° Row-1R
2	External Relief Dia	7.0mm	All Rows					
3	External Relief Depth		42mm					Discuss with Neeraj Sir
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	08	24			
	Inspected By (Sign) & Date		Ramanpreet Singh 16/08/24					

Reviewed by (Engineer-CNC) 16/8/24

Manager-QA

Scanned with CamScanner